0.00

0.00

3.1.23 36

Quality Control

120

Quality Control

QC8- Inspect parts - second check

Memo

120

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

					i				QA Closed:	Date	
Work Orde	er:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		<u> </u>		Descri	ption of work order update	Initial	Δι	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	1	cription	Date	Verification	QC Inspector
Doc/Data	Dute	Jiep	Qty		or won comormance	Cinci zii	5		Dute	Vermedicit	Qo mapeeto.
Equip/Tooling											
Operator					,						
Material	\dashv										
Setup											
Other											
Process											
Supplier											
Training				· I	<u> </u> - 		1				
Unapproved					!						
					F	AULT CAT	EGORY				
Landir	ng Gear				General				_	<u>. </u>	
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to (o/s	BOM/Route	Hardv	/are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.		<u> </u>	Burrs	Instru	ctions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Main	tenance		Part Moved		
Ĺ	Heat Trea	at			Countersink	Mislal	peled		Positioned \	Wrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	'Surge	Other
	Ripples in	Bend			Drill Holes	Offset					
1	Torque W			n L	Drawing	Out of Calibration					
	Turning S				Finish	Out o	f Sequence				
l	Wave/Tw	ist in Tub	e		Folio	Outsid	de Dimensions				

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 93821 Page 2 November-27-12 11:42:29 AM Item ID: D2282-3 Accept *N900040100* Setup Start **Revision ID:** Item Name: Tube **Start Qty: 30.00 Start Date:** 11/22/12 **Cust Item ID:** Required Date: 12/21/12 Req'd Qty: 30.00 **Customer:** Reference: Run Process Plan: **Tooling: Approvals:** Date: Date: Stop Date: _____ SPC (Y/N): OC: Date: Sequence ID/ Tool ID Operation Set Up/ Tool # Plan Reject Reject Accept Insp. **Work Center ID Description** Qty Qty Number Stamp **Run Hours** Code Identify as per dwg & Stock Location: W/A 00/ 130 0.00 *130* EL 13-1-24. Packaging 0.00 Memo *****STOCK IN LARGE FAB***** Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140*

0.00

Memo

Quality Control

MB01.30

												DQA:	Date	:
NCR:	Yes	/ No					WORK ORDER NON	-co	NFORM	MANCE / UP	DATE	QA Closed:	Date	•
							DISPOSITION			<u> </u>	AGAINST DE		· · · · · ·	
Vork Ord	er:						<u>-</u>			AGAINST DEPARTMENT/PROCESS				
Part No.					Rework Scrap Use-as-is		Machining Small		Crosstube Small Fab Finishing	-1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR	No.						Work Order Update			Large Fab	Composite	_	Supplier	
Root					Des	crip	otion of work order update		Initial	Ac	ction	Sign &		
Cause		Date	Step	Qty		О	r Non-conformance	CI	nief Eng	Desc	cription	Date	Verification	QC Inspector
oc/Data ¡uip/Tooling														
perator							· ·							
laterial			1				•	!						
etup														
ther														
rocess			<u> </u>											
upplier	_													
raining	<u></u>							1						
napproved	<u> </u>											<u></u>		<u> </u>
								FAU	LT CATE	GORY				
Land	ing (7					General	·	٦		_	٦	Г	¬
	\vdash	Bending	_				Bend	<u> </u>	Grain		<u> </u>	Ovalized	-	Pressure/Forced
	\vdash	Centre No	ot Concei	ntric to O)/S		BOM/Route	·	Hardwa		<u> </u>	Over/Under	i —	Temperature/Cure
	\vdash	Cracks					Broken/Damaged	·	⊣ `	on Incomplete	,, <u> </u>	Part Incorre)	Weld
	<u> </u>	Crushed/	Crimped.	-			Burrs	; -		ions Incomplete,	/Unclear	Part Lost/M	_	Wrong Stock Pulled
Cuffs Contamination						<u> </u>	Mainte		-	Part Moved				
Heat Treat Countersink						_	Mislabe		<u> </u>	Positioned \		¬		
Inspection Strip in Tube Cut Too Short						1	Misread	1		Power Loss,	'Surge	Other		
	<u></u>	Ripples in					Drill Holes	_	Offset					
	L	Torque W					Drawing	, _	┥	Calibration				W + +70
	1	Turning S	equence			l	Finish		Out of 9	Sequence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Picklist Print

November-27-12 11:42:29 AM

Work Order ID:

93821

Parent Item:

D2282-3

Parent Item Name:

Tube

Start Date: 11/22/12

Required Date: 12/21/12

Page 1

Start Qty: 30.00

6.288

Required Qty: 30.00

Comments:

IPP Rev:A

Removed from 9 Digit

05-12-02 JLM

116856

117598

120633

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.675W.091 304 RD Tube .675 x .091V	v	Purchased	No			100	f	123.4740	0.1979 _ 6 · 2	6.249474 88		H 13-	01-23
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT017		123.474							
				116	386	31.149							

39.1

3.34

49.885

								1				DQA:	Date:	
NCR:	Yes	/ No				WORK	ORDER NO	N-COI	NFORM	MANCE / UP	DATE	OA Closed:	Dete	
				· · ·								QA Closed:	Date:	
Nork Ord	er:					1	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No. NCR No.				Rework Scrap Use-as-is			f Therm	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	┥	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other		
NCR	No.					Wor	k Order Update	:[]		Large Fab	Composite	_	Supplier	
Root					Desc	ription of w	ork order updat	e	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-cor	nformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved														
								FAUL	LT CATE	GORY				
Land	ing (Gear			_	_	General		7			_	-	_
		Bending Centre No Cracks Crushed/0		ntric to O/	's	Bend BOM/Rou Broken/D Burrs	Damaged		Instruct	on Incomplete ions Incomplete/	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M	ct ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
	F			Contamina Counters			Mainte Mislabe			Part Moved Positioned \				
		Inspection	-	Tube	 	Cut Too Si			Misread		-	Power Loss,		Other
		Ripples in			 	Drill Hole			Offset		<u> </u>	_	~ <u>L</u>	
		Torque W		xtrusion		Drawing		, [Out of (Calibration				
		Turning Se	equence		Г	Finish		' [Out of	Sequence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

DART AEROSPACE LTD	Work Order:	93821
Description: Handle Tube	Part Number:	D2282-3
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

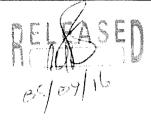
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	٠.
2.375	+0.000/-0.020	2.367	/		5608	Vein	1,5
Ø9 -493	+0.006/-091						
Ø0.675	+/010	.683	/		V		· · ·
							•
,							

Measured by:	SI	Audited by:	9-85	Prototype Approval:	N/A
Date:	13-01-23	Date:	B.1.23	Date:	N/A

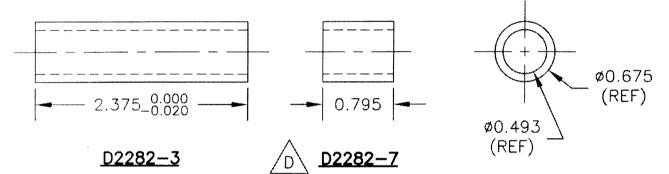
Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue P/O D350-615-041	KJ/RF	
В	05.04.19	Tolerance changed	KJ/JLM	
С	06.03.15	Dwg Rev update	KJ/JLM _{I A}	
D	09.10.01	Dimensions updated	KJ %	M
	•		77	



DESIG	4)	TODAWA: TOV	*		
	BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHEC	KED.:	APPROVED	DRAWING NO.	REV	. ε
	W	1/400	D2282 SHEET	1 OF	2
DATE			TITLE	SC	NE
05.0	06.07		HANDLE TUBES		1:1
Α		94.10.14	NEW ISSUE		
В		95.03.23	RE-DESIGN		



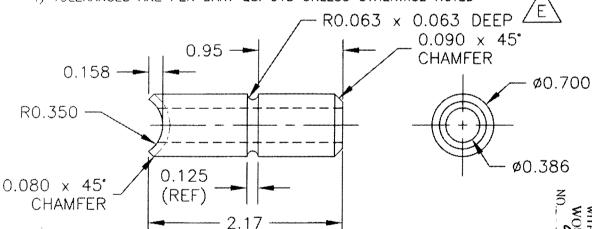
05.0	06.07	HANDLE TUBES 1:
Α	94.10.14	NEW ISSUE
В	95.03.23	RE-DESIGN
С	97.10.20	CORRECTED NUMBERING SCHEME
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D D2282-5

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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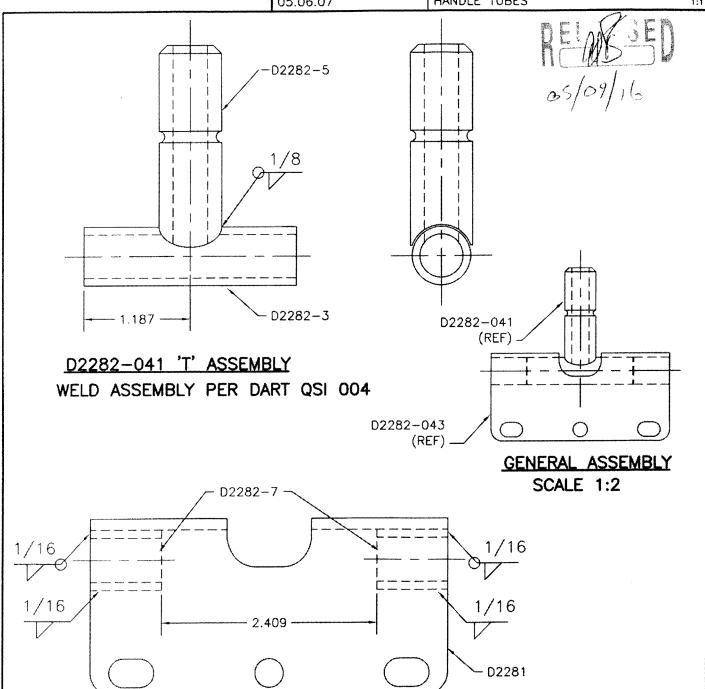
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SUBJECT TO "



DESIGN BW	DRAWN BY	DART AEROS HAWKESBURY, ON	
CHECKED	APPROVED	DRAWING NO.	REV. E
u'	1 1116	D2282	SHEET 2 OF 2
DATE		TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

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